

Work Order ID 84935

May-29-12 3:00:43 PM

\*84935\*

Page 1

Item ID: D209-669-043

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop

\*NS2\*

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 12/05/29 Tooling:

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D2906	Rev B

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy D209-669 bluefile & type labels per PPP D205669-043 Chg 002

003

per ECD 12-5-18

110

\*110\*

Skidtubes

Skidtubes

0.00

0.00

0.00

0.00

- Inspect mat'l D2500-1-190 for damage

Memo

- Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

- Open holes to 0.500" as per Dwg D2906 without cutting fluid

- Deburr and blow out all chips from

- Acid etch and Alodine tube per QSI 005 4.1

> CF 12-6-18

SAD 12-06-18

ZG 12-6-18

60%

80%

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/15	140	Fwd bend is overbent. height = 2.20"	GP 12/7/15	Acceptable			GP 12/7/15	

NOTE: Date & initial all entries

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Page 2

Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop

**\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC3- Inspect Part Finish

0.00

**\*120\***

QC

Memo

0.00

Quality Control

(1)

SAD

12-06-18

130

**\*130\***

Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date: 12-01-12

Start Time: 15:45 Date: 12-6-18

Fin Time: \_\_\_\_\_ Date: \_\_\_\_\_

Pick:

Qty P/N description

1 D2926-3 Web

B/N

84949

CEAD

12-6-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 84935**

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**Item ID:** D209-669-043

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

**Revision ID:**

**Item Name:** Replacement Skidtube

Stop

**\*NS2\***

**Start Date:** 29/05/2012 **Start Qty:** 1.00 **\*1\***

**Cust Item ID:**

**Required Date:** 16/07/2012 **Req'd Qty:** 1.00 **\*1\***

**Customer:**

**Reference:**

<b>Approvals:</b>	<b>Process Plan:</b> _____	<b>Date:</b> _____	<b>Tooling:</b> _____	<b>Date:</b> _____	<b>Run</b>	<b>Start</b>	<b>*NR1*</b>
	<b>QC:</b> _____	<b>Date:</b> _____	<b>SPC (Y/N):</b> _____	<b>Date:</b> _____		<b>Stop</b>	<b>*NR2*</b>

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty.</b>	<b>Reject Qty.</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
--	----------------------------------	------------------------------	----------------	---------------	----------------------	------------------------	------------------------	--------------------------	------------------------

140

**\*140\***

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - CROSSTUBES

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty.

Reject  
Qty.

Reject  
Number

Insp.  
Stamp

150

**\*150\***

Skidtubes

Skidtubes

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty.

Reject  
Qty.

Reject  
Number

Insp.  
Stamp

Memo 0.00

-Deburr ends and remove marks from bending

- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.

160

**\*160\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty.

Reject  
Qty.

Reject  
Number

Insp.  
Stamp

Memo 0.00

12/12/07/06 / CF 12.1.9

PTO E

W/O: 64935		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-7-10	140	QC6 needs to be added after Bending	BS	12-7-10			

Part No: D1091069-043 PAR #: \_\_\_\_\_ Fault Category: Landing gear | skip tube NCR: Yes No DQA: ✓ Date: 12/07/10  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 12-1583		WORK ORDER NON-CONFORMANCE (NCR) #51403						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-7-10	140	Tube Not cut properly after bending. 13.4" (Ref) Measurement is 12.2" and 18.9 (Ref) measurement is 19.5".  RC: Employee error, Tube was not positioned properly on Saw Table. Reason: employee → employees were trained PA: Add QC6 after bending	W 12-7-10	SCRAP 12/7/10 employees were trained	C/F 12-7-10 12-07-10	SAP 12-07-10	✓ 12-07-10 12-07-10	✓ 12-07-10 12-07-10

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID** 84935

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**Item ID:** D209-669-043

Accept

\*N900040100\*

Setup Start

\*NS1\*

**Revision ID:**

**Item Name:** Replacement Skidtube

Stop

\*NS2\*

**Start Date:** 29/05/2012 **Start Qty:** 1.00 \*1\*

Cust Item ID:

**Required Date:** 16/07/2012 **Req'd Qty:** 1.00 \*1\*

Customer:

**Reference:**

<b>Approvals:</b>	<b>Process Plan:</b> _____	<b>Date:</b> _____	<b>Tooling:</b> _____	<b>Date:</b> _____	<b>Run</b>	<b>Start</b>	*NR1*
	<b>QC:</b> _____	<b>Date:</b> _____	<b>SPC (Y/N):</b> _____	<b>Date:</b> _____	<b>Stop</b>		*NR2*

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
240 <b>*240*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	<b>Memo</b>	0.00							
	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
250 <b>*250*</b> Packaging	Packaging	0.00							
Packaging	<b>Memo</b>	0.00							
	Identify and pack for shipping as per PPPD209-669-043								
	Location: _____								
	PPP Rev: _____								
260 <b>*260*</b> QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	<b>Memo</b>	0.00							

1/207/11

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 84935

\*84935\*  
\*D209-669-043\*

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD  
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No				Each	81.0000	**	19		DE 12/07/06	

\*D4202-1\*

Spacer

Location B84763 Loc Qty Loc Code

LG 5  
77727 5  
LG002 76  
78806 6  
79810 70

(19)

D2500-1-190

\*D2500-1-190\*

Ext'n - I Beam Tube 4"

Location Loc Qty Loc Code

HALL 91  
74777 14  
80061 77

(1)

D2926-3

\*D2926-3\*

Web

D2855

\*D2855\*

Cap

Location Loc Qty Loc Code

110 Each 0.0000

1

1

CF 12-6-18

CF 12-6-18

B84949 Loc Qty Loc Code

230 Each 21.0000

2

2

\*\*

Location Loc Qty Loc Code

FP002 21  
65519 2  
73347 16  
75074 3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 84935

**\*84935\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

**\*\*****\*AN3-5A\***

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1090	
115371	46	
117423	124	
118626	31	
119355	200	
120187	500	
121185	189	

AN960JD10L

NAS1149D0332J Purchased

No

230

Each

0.0000

4

4

**\*\*****\*AN960.JD10I \***

Washer

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

**\*\*****\*AL S7-1032-130\***

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	51	
117717	27	
118966	22	
119775	2	
ST282	2085	
119530	73	
120181	12	
121444	2000	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Picklist Print**

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Page 3

**Work Order ID:** 84935**Parent Item:** D209-669-043**Parent Item Name:** Replacement Skidtube**\*84935\***  
**\*D209-669-043\*****Start Date:** 29/05/2012**Start Qty:** 1.00**Required Date:** 16/07/2012**Required Qty:** 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

**\*\*****\*AN3C4A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1458	
120187	57	
120521	28	
120769	38	
121205	1000	
121556	335	

AN960C10L

NAS1149C0332 R

Purchased

No

230

Each

0.0000

44

44

**\*\*****\*AN960C10I \***

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

**\*\*****\*D2594-3\***

O-Ring, 205 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	2418	
65518	41	
79496	984	
79573	50	
79755	1343	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 84935

\*84935\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

\*\*

\*D2594-1\*

Plug, 205 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	98	
-------	----	--

73401	30	
-------	----	--

74442	18	
-------	----	--

79495	50	
-------	----	--

FP-A	213	
------	-----	--

73401	0	
-------	---	--

78590	213	
-------	-----	--

D3564-9

Manufactured No

230

Each

22.0000

1

1

\*\*

\*D3564-9\*

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	4	
----	---	--

76950	4	
-------	---	--

FP001	18	
-------	----	--

67590	4	
-------	---	--

69943	1	
-------	---	--

82255	13	
-------	----	--

D3564-11

Manufactured No

230

Each

8.0000

1

1

\*\*

\*D3564-11\*

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	4	
----	---	--

77056	4	
-------	---	--

FP001	4	
-------	---	--

80341	4	
-------	---	--

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID:** 84935**\*84935\***  
**\*D209-669-043\*****Parent Item:** D209-669-043**Parent Item Name:** Replacement Skidtube**Start Date:** 29/05/2012**Required Date:** 16/07/2012**Start Qty:** 1.00**Required Qty:** 1.00

D3564-5

Manufactured No

230

Each

13.0000

1 1

**\*\*****\*D3564-5\***

Wearshoe

Location      Loc Qty      Loc Code

FG	2	
34806	2	
FP001	11	
77609	3	
82254	8	

D3566-1

Manufactured No

230

Each

31.0000

2 2

**\*\*****\*D3566-1\***

Gasket

Location      Loc Qty      Loc Code

FP	-22	
81619	10	
FP002	53	
68924	2	
80919	3	
83898	16	

D3566-5

Manufactured No

230

Each

21.0000

1 1

**\*\*****\*D3566-5\***

Gasket

Location      Loc Qty      Loc Code

FP	12	
82275	12	
FP002	9	
80374	3	
82274	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

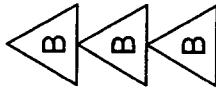
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY	QTY	Part Number	Description
-041	-043	D2906-041	SKIDTUBE ASSEMBLY
X	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1	1	D2926-1	WEB
1	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	1	D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
		AN3C4A AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960UD10L	WASHER



#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2800-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-0411 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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WORK ORDER

NO. 84935 MLC

12/05/2015

REV.	DESCRIPTION	BY	DATE
B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS;	CB	07.08.21
	PG 1: ADD NOTE 10;		
	PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041;		
	PG 3 C3: CORRECTED -043 CAP P/N;		
	PG 3 D7: 38 PLACES WAS 44 PLACES;		
A	NEW ISSUE	CP	04.06.22
RELEASED		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
07.04.04		DRAWING NO. D2906	REV. B SHEET 1 OF 3
		TITLE AH-1 (209) SKIDTUBE ASSEMBLY	SCALE NTS
DATE	07.08.21		

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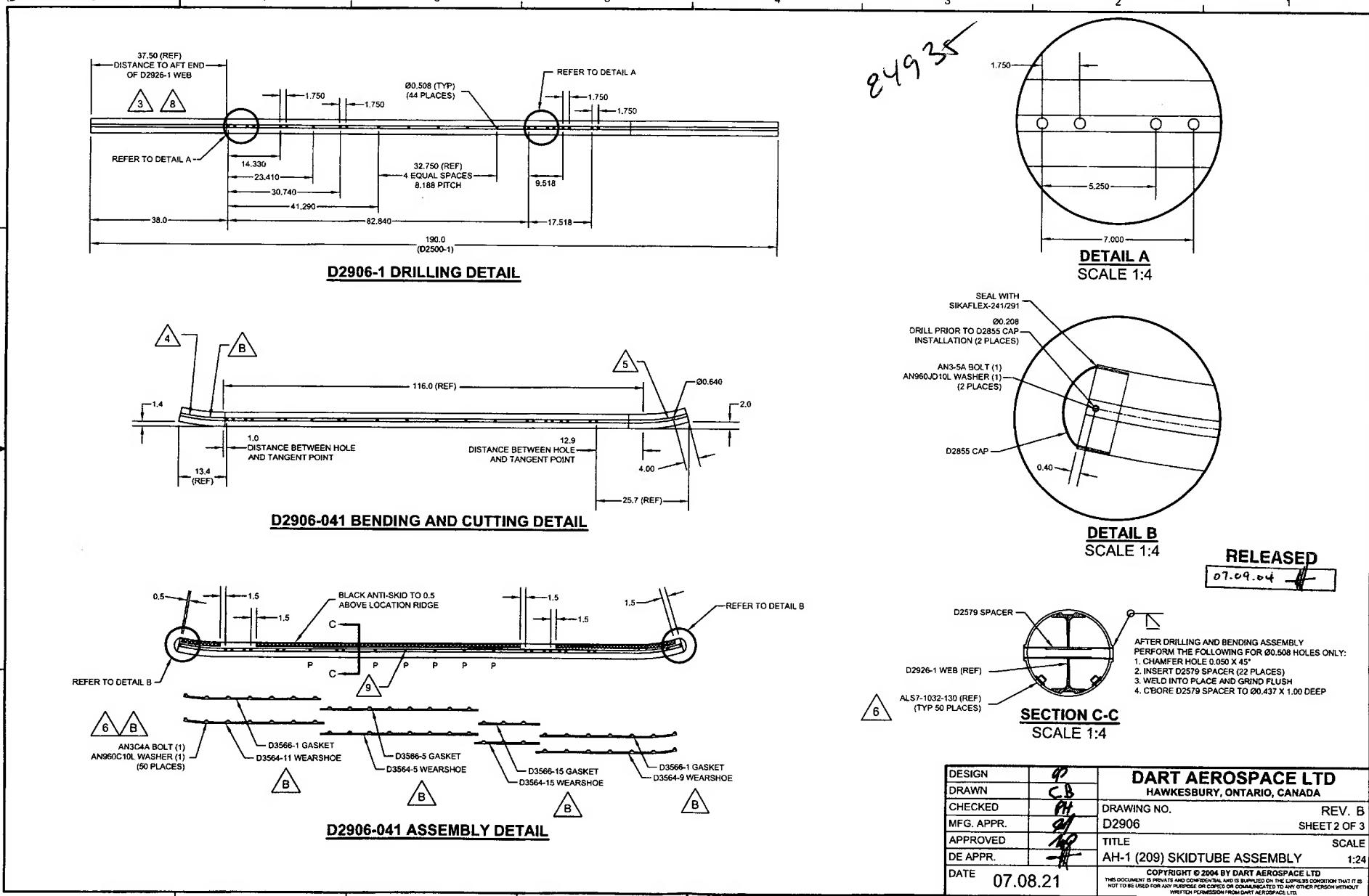
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



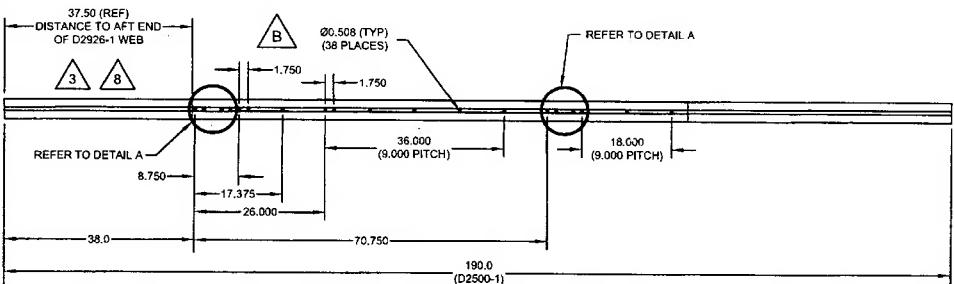
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

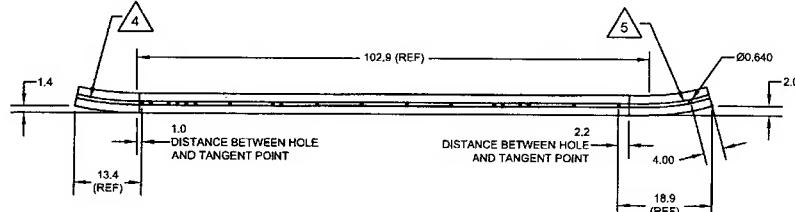
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

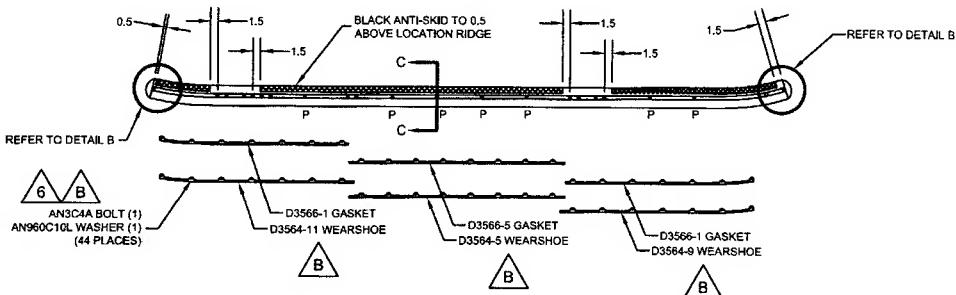
NOTE: Date & initial all entries



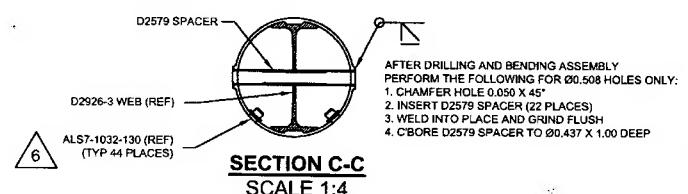
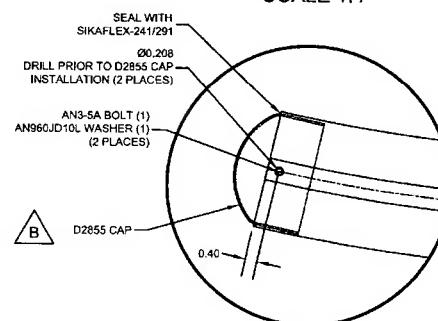
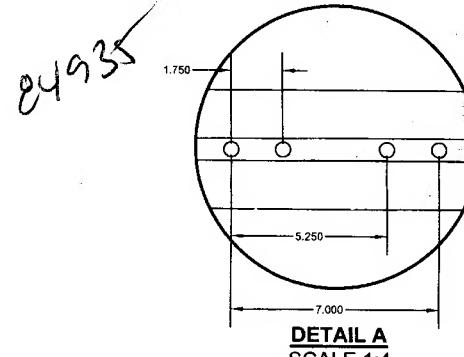
**D2906-3 DRILLING DETAIL**



**D2906-043 BENDING AND CUTTING DETAIL**



**D2906-043 ASSEMBLY DETAIL**



DESIGN	99	DART AEROSPACE LTD
DRAWN	CB	HAWKSLEY, ONTARIO, CANADA
CHECKED	PH	REV. B
MFG. APPR.	PH	SHEET 3 OF 3
APPROVED	AD	TITLE
DE APPR.	AD	SCALE
DATE	07.08.21	AH-1 (209) SKIDTUBE ASSEMBLY 1:24

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TOTAL Length  
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries